

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006340**Date Inspected:** 20-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/20/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

West Deviation Saddles:

W2E1 - Located in #2 Machine Shop, having lifting lugs removed by machining/milling process.

W2E2 - Final Machining of section taking place in Machine Shop #2.

W2E3 - Sections are now in contact, in Fabrication #4.

W2W1 - Cast now in Fabrication Shop #4 awaiting the completion of beveling process, currently both sit idle.

W2W2 - Sitting Idle in Foundry, built up section has one active welder, M. Yamashita, weld Identification of 73-4195, is performing Shielded Metal Arc Welding (SMAW) on joint W2S-2L utilizing procedure SJ3011-1, Horizontal (2G) position. Quality Control (QC) CWI Mr. Chung Fu Kuan is proactive in verifying the parameters set forth.

W2W3 - Cast is idle with blasted surface condition, still awaiting final NDE.

Tower Saddles:

T1-1 - Built up Saddle section is in the #4 Machine Shop being Final Machined.

T1-2 - Sitting idle in Fabrication Shop #4, no welding occurring at this time.

T1-3 - Cast section is currently in #4 Machine shop having its buttered surfaces machined. Built up section is resting in #4 Fabrication Shop idle.

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East Saddles:

E2E1 - Cast is idle, stage of progression is shaping by way of grinding, still approximately 5% complete.

E2W1 - Wet Magnetic Particle testing being done to cast section, area of interest at this time is the trough, Level I area, in Foundry by H. Kohama (#86). Upon verification of process and procedure it appears that all contract documents, special provisions and Weld Quality Control Plan (WQCP) are being met at this time,

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
